

Work Order ID 57762

April 14, 2010 11:44:30 AM



Page 1

Item ID: D2345

Accept



Setup Start



Revision ID:

Stop



Item Name: Lock Channel

Start Date: 4/14/10 Start Qty: 10.00



Cust Item ID:

Required Date: 4/19/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2345

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2345 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Debur if necessary

304 .050

Debur = 7 m/h 10/04/10 (15X) (15)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-4-19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8064/20

(15)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 57762

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April 14, 2010 11:44:30 AM

Item ID: D2345

Accept



Setup Start



Revision ID:

Stop



Item Name: Lock Channel

Start Date: 4/14/10 Start Qty: 10.00



Cust Item ID:

Required Date: 4/19/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|----------------|--------------|--------------|----------------|---------------|------------------|--|
| 160 Packaging Packaging | Identify as per dwg & Stock Location: <u>11</u> Memo | 0.00 0.00 | | | | <u>10-4-21</u> | | <u>152</u> | <u>SP</u> |
| 170 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <u>10/04/22</u> <u>mf</u> <u>10-4-22</u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:44:29 AM

Page 1

Work Order ID: 57762



Parent Item: D2345



Parent Item Name: Lock Channel

Start Date: 4/14/10

Required Date: 4/19/10

Comments: IPPRevB 99.05.31 Re-format DM
IPP Rev:C Now on Waterjet 06-10-26 JLM

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304S18GA | | Purchased | No | | | 100 | sf | 142.0179 | 0.5558 | 19 | | |



304/316 .050 Sheet



B10-4-19

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|----------|----------|
| Main Warehouse | | |
| MAT20 | 142.0179 | |
| 108156 | 1.7 | |
| 111743 | 11 | |
| 112885 | 33.3179 | |
| 113062 | 96 | |

15

111743

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 34412 |
| Description: Lock Channel | Part Number: | D2345 |
| Inspection Dwg: D2345 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

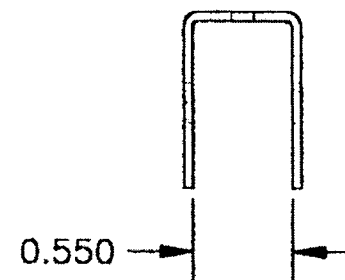
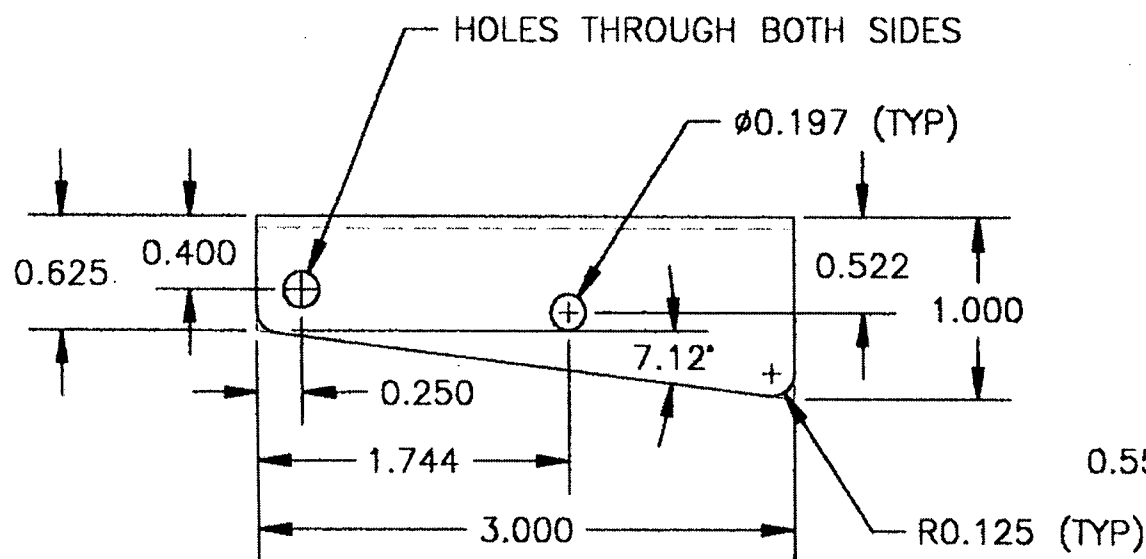
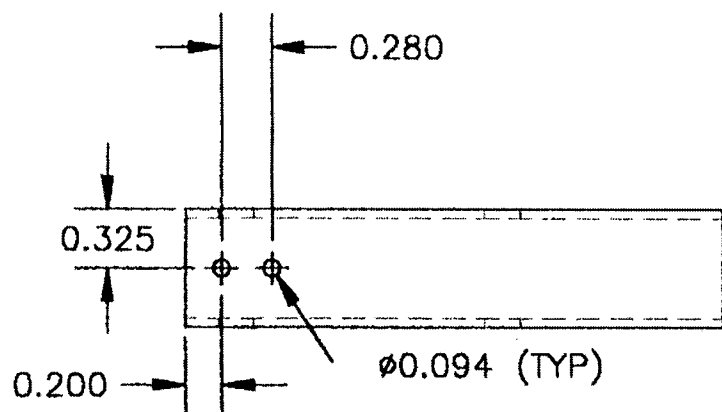
[illegible]



RELEASED
99002-16

WJ
57762

| | | | | |
|---------|------------|----------|--------------|--|
| DESIGN | B WILLIAMS | DRAWN BY | B WILLIAMS | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA |
| CHECKED | B WILLIAMS | APPROVED | | DRAWING NO. D2345 |
| DATE | 95-02-21 | TITLE | LOCK CHANNEL | REV. A |
| | | | | SHEET 1 OF 2 |
| | | | | SCALE 1:1 |

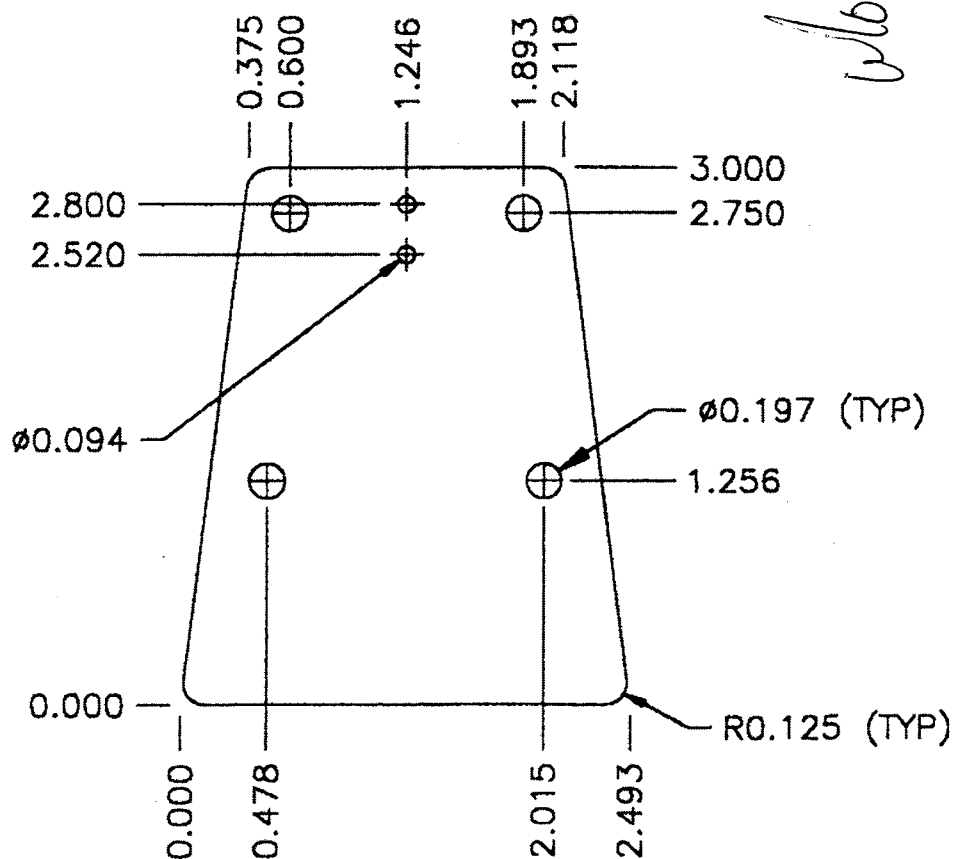


MATERIAL: 304/316 SS 0.050 THICK
BEND RADIUS: 0.032



| | | | |
|---------------|-------------------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| B WILLIAMS | B WILLIAMS | DRAWING NO. | REV. A |
| CHECKED BW | APPROVED [Signature] | D2345 | SHEET 2 OF 2 |
| DATE | TITLE | SCALE | |
| 95:02:21 | LOCK CHANNEL | 1:1 | |

RELEASED
[Stamp]



D2345 FLAT PATTERN
MATERIAL: 304/316 SS 0.050 THICK